

**CLAIMS**

What is claimed is:

1. A dish rack for an automated dishwasher, comprising:  
a metal frame configured to support dishes, and  
an exterior coating covering at least a portion of the metal frame and comprising:  
an electrocoated layer on the metal frame, and  
a polymer layer on the electrocoated layer;  
5 whereby the exterior coating protects the metal frame from corrosion while providing an aesthetic appearance.
2. The dish rack according to claim 1 wherein the electrocoated layer is non-metallic.
3. The dish rack according to claim 1 wherein the electrocoated layer is a paint layer.
4. The dish rack according to claim 3 wherein the paint layer is non-metallic.
5. The dish rack according to claim 1 wherein the polymer layer is a thermoplastic.
6. The dish rack according to claim 5 wherein the thermoplastic is a non-hydrocarbon carbon-chain polymer.
7. The dish rack according to claim 6 wherein the non-hydrocarbon carbon chain polymer is a polyvinyl chloride.
8. The dish rack according to claim 5 wherein the thermoplastic is a polyvinyl chloride blend.
9. The dish rack according to claim 1 wherein the metal frame comprises a wire-form having multiple interconnected wires.

10. The dish rack according to claim 9 wherein the wire form defines a bottom wall and a peripheral wall extending upwardly from the bottom wall to form an open-top, dish-holding recess.

11. The dish rack according to claim 10 and the wire form further comprising at least one set of tines located within the dish-holding recess.

12. The dish rack according to claim 1 wherein the entire metal frame is covered by the exterior coating.

13. The dish rack according to claim 1 wherein the exterior coating further comprises a primer layer between the electrocoated layer and the polymer layer.

14. The dish rack according to claim 13 wherein the primer layer comprises a water-based primer.

15. The dish rack according to claim 13 wherein the primer layer comprises a non-water-based primer.

16. The dish rack according to claim 15 wherein the primer layer comprises an acetone-based primer.

17. The dish rack according to claim 15 wherein the primer layer comprises a methyl ethyl ketone-based primer.

18. The dish rack according to claim 13 wherein the electrocoated layer is non-metallic.

19. The dish rack according to claim 13 wherein the electrocoated layer is a paint layer.

20. The dish rack according to claim 19 wherein the paint layer is non-metallic.

21. The dish rack according to claim 19 wherein the polymer layer is a thermoplastic.
22. The dish rack according to claim 21 wherein the thermoplastic is a non-hydrocarbon carbon -chain polymer.
23. The dish rack according to claim 22 wherein the non-hydrocarbon carbon chain polymer is a polyvinyl chloride.
24. The dish rack according to claim 21 wherein the thermoplastic is a polyvinyl chloride blend.
25. The dish rack according to claim 21 and further comprising a corrosion-resistant layer between the electrocoated layer and the metal frame.
26. The dish rack according to claim 25 wherein the corrosion-resistant layer comprises an iron phosphate layer.
27. The dish rack according to claim 25 wherein the corrosion-resistant layer comprises a zinc phosphate layer.
28. The dish rack according to claim 25 wherein the corrosion-resistant layer comprises a tri-chrome sealer layer.
29. An automated dishwasher, comprising:
  - a wash tub having top, bottom, side, and rear walls, which collectively form an open-faced wash chamber;
  - 5 a door hingedly mounted relative to the wash tub for movement between an open and closed conditions to selectively close the open-faced wash chamber;
  - a dish rack located within the open-faced wash chamber and comprising a metal frame configured to support dishes; and
  - an exterior coating covering at least a portion of the metal frame and comprising:
    - an electrocoated layer on the metal frame, and
    - 10 a polymer layer on the electrocoated layer;

whereby the exterior coating protects the metal frame from corrosion while providing an aesthetic appearance.

30. The automated dishwasher according to claim 29 wherein the exterior coating further comprises a primer layer between the electrocoated layer and the polymer  
15 layer.

31. The automated dishwasher according to claim 30 wherein the primer layer comprises a water-based primer.

32. The automated dishwasher according to claim 30 wherein the primer layer comprises a non-water-based primer.

33. The automated dishwasher according to claim 32 wherein the primer layer comprises an acetone-based primer.

34. The automated dishwasher according to claim 32 wherein the primer layer comprises a methyl ethyl ketone-based primer.

35. The automated dishwasher according to claim 30 wherein the electrocoated layer is non-metallic.

36. The automated dishwasher according to claim 30 wherein the electrocoated layer is a paint layer.

37. The automated dishwasher according to claim 36 wherein the paint layer is non-metallic.

38. The automated dishwasher according to claim 30 wherein the polymer layer is a thermoplastic.

39. The automated dishwasher according to claim 38 wherein the thermoplastic is a non-hydrocarbon carbon-chain polymer.

40. The automated dishwasher according to claim 39 wherein the non-hydrocarbon carbon chain polymer is a polyvinyl chloride.

41. The automated dishwasher according to claim 38 wherein the thermoplastic is a polyvinyl chloride blend.

42. The automated dishwasher according to claim 38 and further comprising a corrosion-resistant layer between the electrocoated layer and the metal frame.

43. The automated dishwasher according to claim 42 wherein the corrosion-resistant layer comprises an iron phosphate layer.

44. The automated dishwasher according to claim 42 wherein the corrosion-resistant layer comprises a zinc phosphate layer.

45. The automated dishwasher according to claim 42 wherein the corrosion-resistant layer comprises a tri-chrome sealer layer.